

Date: Thursday, 17/07/2008 11:45:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT ASSEMBLY
Job Number	: 40582		
Estimate Number	: 13461		
P.O. Number	:	Part Number	: D2313
This Issue	: 17/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2313 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: D
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 05/08/2008
Checked & Approved By	: <u>JLO 08.7.17</u>	Qty:	4 Um: Each
Comment	: Est: rev A 08.07.16 new issue EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2285	Tube Locator
-----	-------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube Locator

batch: B40618

09.05.22 4

2.0	D2286	Heater Support
-----	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Support

batch: B40636

09.05.22 4

3.0	D2290	Heater Tube
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube

batch: B40619

09.05.22 4

4.0	D22911	Heater Tube 4"
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 4"

batch: B40620

09.05.22 4

5.0	D2292	Heater Tube 4"
-----	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

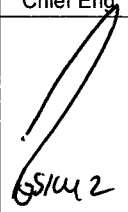
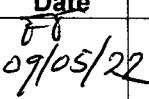

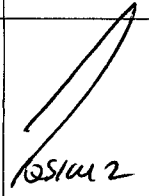
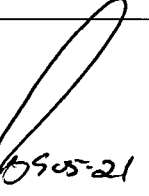
Heater Tube 4"

batch: B47174=2B35339=1B40621=1

09.05.22 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2313 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (S) Date: 09/05/27
 QA: N/C Closed: _____ Date: _____

NCR: <u>40582</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/22	9	QTY x1 SCRAP Flairing Tool. mal- function P		Scrap/Destroy No replace	 09/05/22	 09/05/20		 09/05/21
		R.C. Process/Tooling						

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 11:45:49 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT ASSEMBLY

Job Number: 40582

Part Number: D2313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2293

Heater Tube 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 6"

batch: 840622

PL 09.05.22 4

7.0

AN81816D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m9628

PL 09.05.22 4

8.0

MS2081916D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

batch: ~~2274~~ 2535

PL 09.05.22 4

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld as per Dwg D2313

PL 09.05.25 4

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09.05.26 (4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 09/05/26 (24)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 166

9/5/26

SP

(4x)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mf 09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	D2313	REV. D SHEET 1 OF 2
DATE Jan. 10, 1995		TITLE INLET WELDMENT ASSEMBLY	
D	96:04:18	MODIFIED MASTER PARTS LIST	

QTY	Part No.	Description
X	D2313	INTAKE WELDMENT ASSEMBLY
2	D2285	LOCATOR CROSS
1	D2289	END PLATE
1	D2290	JET PIPE
1	D2291-1	4" RING
1	D2292	4" RING
1	D2293	6" RING
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40582

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

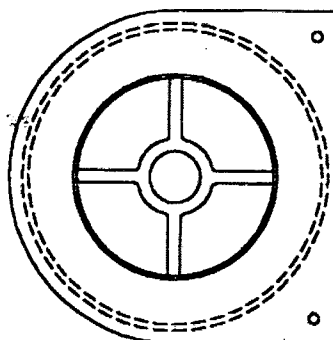
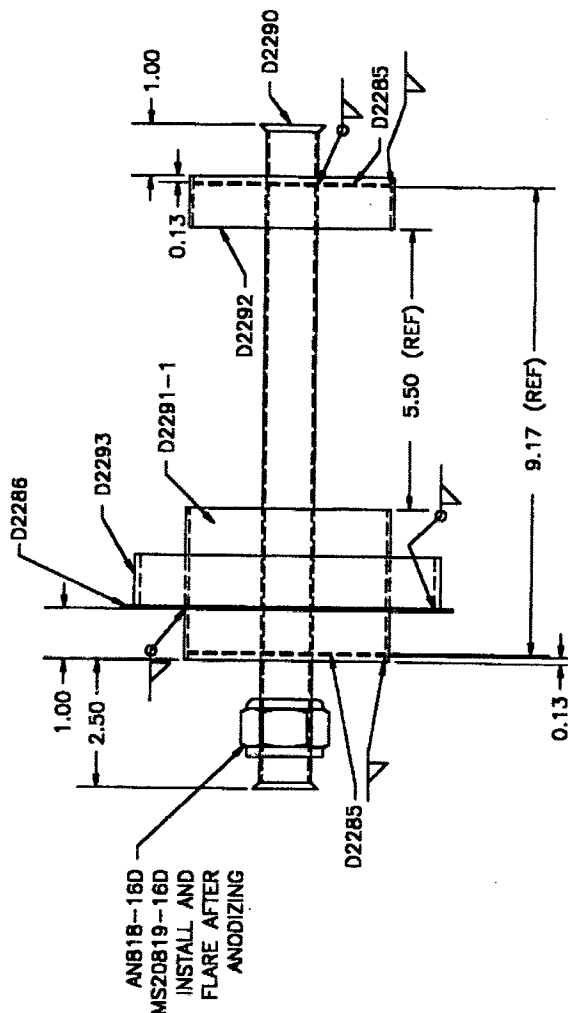
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2313	REV. D SHEET 2 OF 2
DATE Jan. 10, 1995		TITLE INLET WELDMENT ASSEMBLY	SCALE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 40582

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries